

SLUT









Date: Tuesday, 08/08/2006 9:07:10 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SADDLE
Job Number	: 28096	Part Number	: D35001
Estimate Number	: 12451	Drawing Number	: D3500 PREL <i>REV. 06.08.09</i>
P.O. Number	: <i>NIA</i>	Project Number	: N/A
This Issue	: 08/08/2006 S.O. No. : <i>NIA</i>	Drawing Revision	: PREL
Prsht Rev.	: NC	Material	: <i>NIA</i>
First Issue	: <i>NIA</i> Type : MACHINED PARTS	Due Date	: 15/08/2006
Previous Run	: 27654	Qty:	32 Um: Each
Written By	: <i>SEE COMMENT BELOW</i>		
Checked & Approved By	: _____		
Comment	: Est Rev:A New Issue 06-06-15 JLM		<i>8 ASAP</i>

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D6102013	6061-T6 7.0x6.5x2.0
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 32.0000 Each(s) 6061-T6 7.0x6.5x2.0 350 Saddle Billet Batch: <i>B27814</i> <i>SA</i>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <i>SA</i> Double check by: <i>J.G</i> 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets 4-Deburr 5-Tumble to remove sharp edges.		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SA 06.08.09</i>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <i>J.G 06/08/09 8</i>		

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 28096

Part Number: D35001

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m.

06-08-09

(8)

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-09-09 (8)

##
for J. D. [unclear]
test

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10/6/29 (5)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W

06-08-09

10/6/29 (5)

9.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(8)
06/08/10

Job Completion



10/6/08/09

Work Order: 28096

Part Number: D3500-1

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FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article☐ Prototype

	Reference	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.820		1.818	/			
.250		.254	/			
.250		.249	/			
.150		.152	/			
.625		.635	/			
.110		.119	/			
3.614		3.614	/			
.556		.547	/			
1.125		1.125	/			
2.250		2.250	/			
2.500		2.501	/			
2.825		2.823	/			
6.000		6.005	/			
6.510		6.509	/			
Ø.257		Ø.259	/			
Ø.316		Ø.319	/			
.500		.497	/			
.250		.243	/			
Ø.484		Ø.484	/			
.500		.499	/			
.375		.379	/			
1.180		1.177	/			
3.130		3.151	/			

Audited by: J.G

Date: 06/08/09

Prototype Approval:

Date: N/A

Revised by

Approved

RJNF

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DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.820		1.820	/			
.250		.252	/			
.625		.628	/			
.110		.118	/			
.150		.154	/			
.250		.256	/			
R 1.135		1.132	/			
3.614		3.614	/			
.556		.549	/			
1.125		1.125	/			
2.250		2.250	/			
2.500		2.501	/			
6.000		6.003	/			
6.510		6.510	/			
Ø.257		Ø.258	/			
Ø.316		Ø.319	/			
.500		.498	/			
.250		.256	/			
.135		.130	/			
R 1.585		1.582	/			
Ø.484		Ø.484	/			
.500		.500	/			
1.180		1.180	/			

Measured by:	SD
Date:	0608.09

Audited by:	J.G
Date:	06/08/09

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

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DART AEROSPACE LTD		Work Order:
Description:		Part Number:
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FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.820		1.820	/			
.250		.252	/			
.625		.628	/			
.110		.119	/			
.150		.154	/			
.250		.256	/			
R 1.135		1.132	/			
3.614		3.614	/			
.550		.549	/			
1.125		1.125	/			
2.250		2.250	/			
2.500		2.501	/			
6.000		6.003	/			
6.510		6.510	/			
Ø .254		Ø .258	/			
Ø .316		Ø .319	/			
.500		.498	/			
.250		.256	/			
.135		.135	/			
R 1.585		1.582	/			
Ø .484		Ø .484	/			
.500		.500	/			
1.180		1.180	/			

Measured by:	SD
Date:	06.08.09

Audited by:	J.G
Date:	06/08/09

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

(4)

DART AEROSPACE LTD		Work Order:
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Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.820		1.818	/			
.250		.249	/			
.625		.628	/			
.110		.119	/			
.150		.152	/			
.250		.256	/			
R 1.135		R.1.1315	/			
3.614		3.614	/			
.550		.549	/			
1.125		1.125	/			
2.250		2.250	/			
2.500		2.501	/			
6.000		6.004	/			
6.510		6.511	/			
Ø.254		Ø.258	/			
Ø.316		Ø.319	/			
.500		.497	/			
.250		.248	/			
.135		.135	/			
R 1.585		1.581	/			
Ø.484		Ø.484	/			
.500		.497	/			
1.180		1.180	/			

Measured by:	SD
Date:	06.08.09

Audited by:	J.G
Date:	06/08/09

Prototype Approval:	NIA
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

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DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
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First Article

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1.820		1.818	/			
.250		.250	/			
.625		.628	/			
.110		.119	/			
.150		.152	/			
.250		.256	/			
R 1.135		R 1.131	/			
3.614		3.614	/			
.550		.549	/			
1.125		1.125	/			
2.250		2.250	/			
2.500		2.499	/			
6.000		6.005	/			
6.510		6.510	/			
Ø .257		Ø .257	/			
Ø .316		Ø .319	/			
.500		.507	/			
.250		.250	/			
.135		.135	/			
R 1.583		R 1.581	/			
Ø .484		Ø .484	/			
.500		.500	/			
1.180		1.179	/			

Measured by:	SD
Date:	06.08.09

Audited by:	S.G
Date:	06/08/09

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

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DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
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1.820		1.818	/			
.250		.250	/			
.625		.628	/			
.110		.115	/			
.150		.153	/			
.250		.256	/			
R 1.135		1.131	/			
3.614		3.614	/			
.550		.545	/			
1.125		1.125	/			
2.250		2.250	/			
2.500		2.501	/			
6.000		6.005	/			
6.510		6.510	/			
Ø.257		Ø.257	/			
Ø.316		Ø.316	/			
.500		.499	/			
.250		.245	/			
.135		.135	/			
R 1.585		1.581	/			
Ø.484		Ø.484	/			
.500		.500	/			
1.180		1.180	/			

Measured by: SA	Audited by: J.G	Prototype Approval:
Date: 06.08.09	Date: 06/08/09	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

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DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
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.110		.119	/			
.150		.153	/			
.250		.249	/			
R 1.135		1.132	/			
3.614		3.614	/			
.550		.549	/			
1.125		1.125	/			
2.250		2.250	/			
2.500		2.500	/			
6.000		6.005	/			
6.510		6.510	/			
Ø .254		Ø .254	/			
Ø .316		Ø .316	/			
.500		.500	/			
.250		.252	/			
.135		.135	/			
R 1.585		1.582	/			
Ø .484		Ø .484	/			
.500		.498	/			
1.180		1.180	/			

Measured by: <u>SD</u>	Audited by: <u>J.E</u>	Prototype Approval: <u>N/A</u>
Date: <u>06.08.09</u>	Date: <u>06/08/09</u>	Date:

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DART AEROSPACE LTD		Work Order:	
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.625		.629	/			
.110		.119	/			
.150		.152	/			
.250		.250	/			
R 1.135		1.132	/			
3.614		3.614	/			
.550		.549	/			
1.125		1.125	/			
2.250		2.250	/			
2.500		2.501	/			
6.000		6.004	/			
6.510		6.510	/			
Ø .257		Ø .258	/			
Ø .316		Ø .319	/			
.500		.498	/			
.250		.247	/			
.135		.135	/			
R 1.585		1.582	/			
Ø .484		Ø .484	/			
.500		.500	/			
1.180		1.180	/			

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Date: <u>06.08.09</u>	Date: <u>06/08/09</u>	Date:

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A		New Issue	KJ/RF	

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